

Work Order ID 136057

136057

Page 1

August 27, 2015 1:47:41 PM

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 8/27/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/4/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 0150827 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2221	Rev H

100	Large Fab	0.00
-----	-----------	------

100

Large Fab

Large Fab

Memo

0.04

- 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 - 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 - 3- tack weld mesh on basket as per dwg D2221
- A/R ER316 S.S. Rod Batch: B132768

PLEASE NOTE SEE DWG

IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG

1x CC 15-9-8

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------

110

QC

Quality Control

Memo

0.00

1 SEP 09 2015

DAS
24
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

August 27, 2015 1:47:41 PM

Item ID: D2221

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Basket Base Assembly

Stop *NS2*

Start Date: 8/27/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 9/4/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

Plan Code

**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

SEP 09 2015

**DAE
24
9-89**

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.01

Hand Finishing

1 0159-9.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
130	<i>M 13045</i>					<i>1</i>	<i>φ</i>	<i>15.9.9.</i>	<i>23 98</i>
Powdercoat	Memo	0.01							
Powder Coating	1- Plug holes prior to								
	1ST COAT:								
	START TIME: <i>1:00</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>2:20</i>								
	***** 2nd coat if necessary *****								
	2ND COAT:								
	START TIME: <i>2:45</i>								
	OVEN TEMPERATURE: <i>400°</i>								
	FINISH TIME: <i>3:15</i>								
140	QC3- Inspert Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
						<i>1</i>	<i>φ</i>	<i>15.10.09</i>	<i>DAS 15 989</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																																

MCS SEP 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

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Page 1

Work Order ID: 136057

136057

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 8/27/2015

Required Date: 9/4/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2221-1

Manufactured

No

100

Each

10.0000

1

1

D2221-1

Rib

Location

Loc Qty

Loc Code

WA004

10

121579

4

129923

6

D2221-5

Manufactured

No

100

Each

8.0000

2

2

D2221-5

Rib

Location

Loc Qty

Loc Code

WA004

8

127446

8

D2221-7

Manufactured

No

100

Each

11.0000

1

1

D2221-7

Rib

Location

Loc Qty

Loc Code

WA004

11

125057

5

98039

6

Picklist Print

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Page 2

Work Order ID: 136057

136057

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 8/27/2015

Required Date: 9/4/2015

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

34.0000

2

2

D2232-3

Basket Hinge

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

34

101778

6

115847

20

132731

8

(2x)

D2235-1

Manufactured No

100

Each

7.0000

2

D2235-1

Basket Rib

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

7

127782

2

127783

5

(2x)

D2581

Manufactured No

100

Each

69.0000

2

2

D2581

Mounting Bracket

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

69

132771

69

(2x)

D3442-1

Manufactured No

100

Each

16.0000

2

2

D3442-1

Shim

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

16

121484

14

99654

2

(2x)

Picklist Print

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Page 3

Work Order ID: 136057

136057

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 8/27/2015

Required Date: 9/4/2015

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

10.0000

2

2

D3825-041

Rib Assembly (Basket End)

**

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

10

119029

2

130049

8

(2x)

D3826-041

Manufactured No

100

Each

4.0000

2

2

D3826-041

Rib / Gusset Assembly

**

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

4

127436

4

(2x)

D3827-041

Manufactured No

100

Each

5.0000

1

1

D3827-041

Rib Assembly (Inboard)

**

CL 15-9-8

Location

Loc Qty

Loc Code

WA004

5

120658

1

127627

4

(1x)

D3832-1

Manufactured No

100

Each

0.0000

1

1

D3832-1

Mesh (Base)

**

CL 15-9-8

B129695

(1x)

Picklist Print

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Page 4

Work Order ID: 136057

136057

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 8/27/2015

Required Date: 9/4/2015

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

20.0000

2

2

D3833-1

Mesh (Base End Face)

CC 15-9-8

Location

Loc Qty

Loc Code

WA004

1

132549

1

WA006

19

105890

15

121509

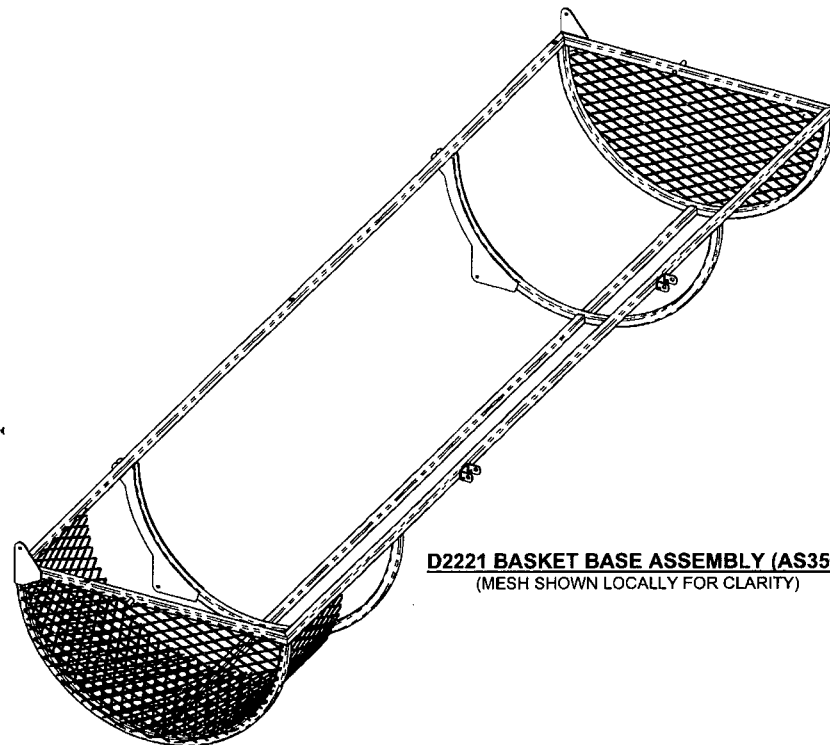
4

B114241

(2x)

9

20150827 SH
2136057.1



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)



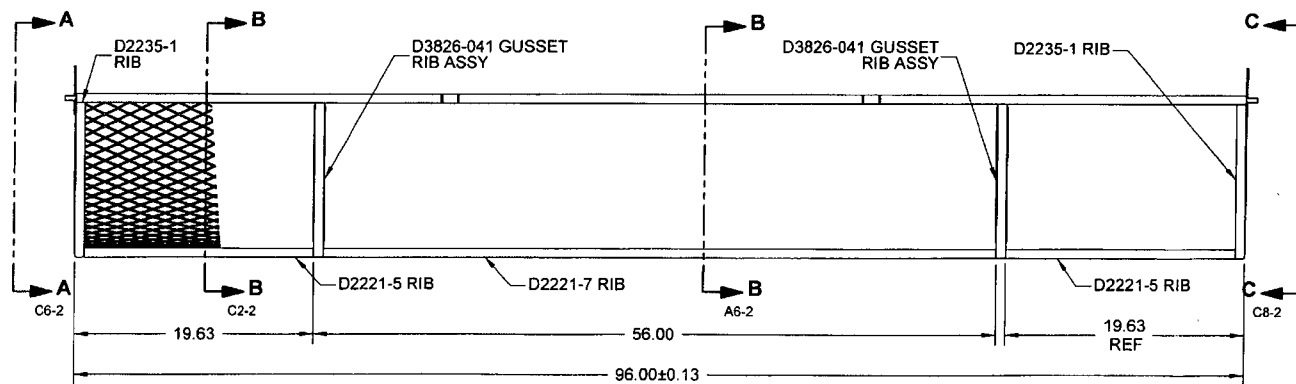
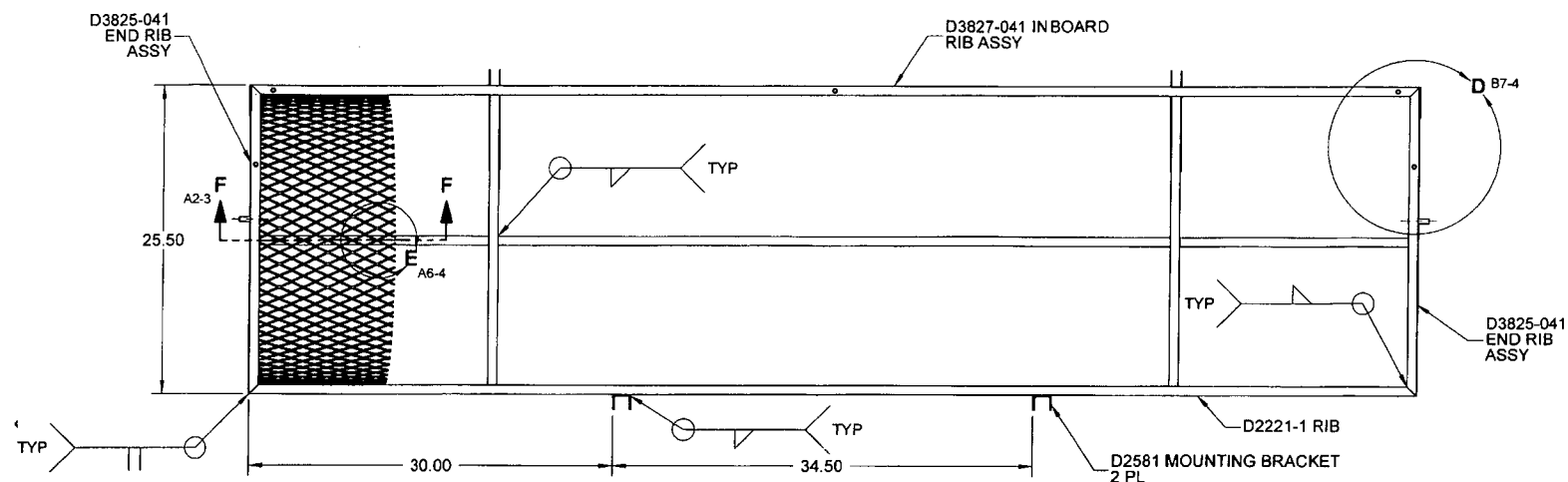
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

REVISION
05/11/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

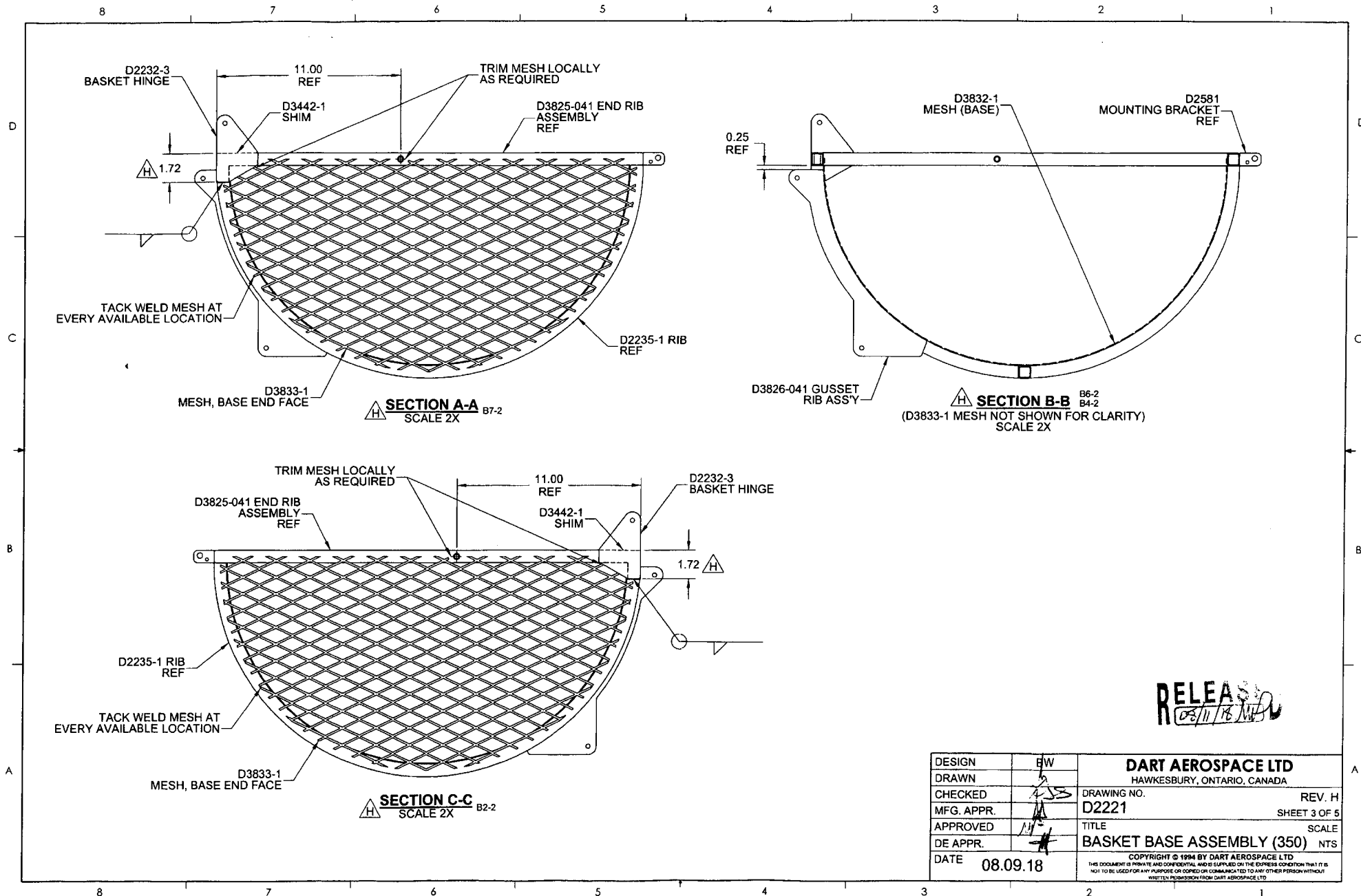
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-11-51-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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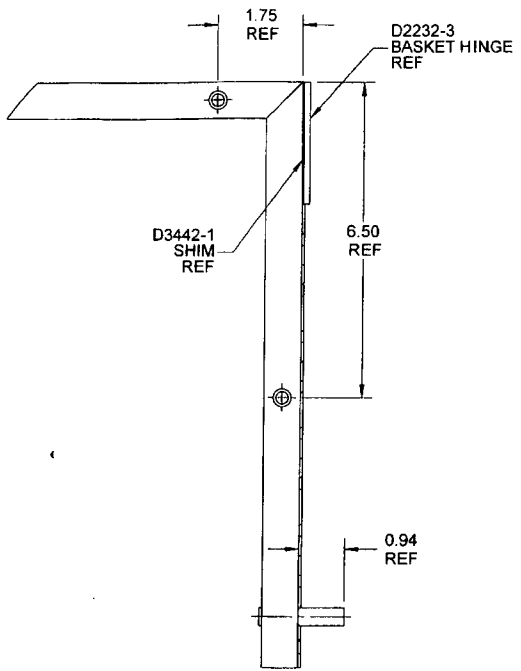
RELEASED

DESIGN	EW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 3 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

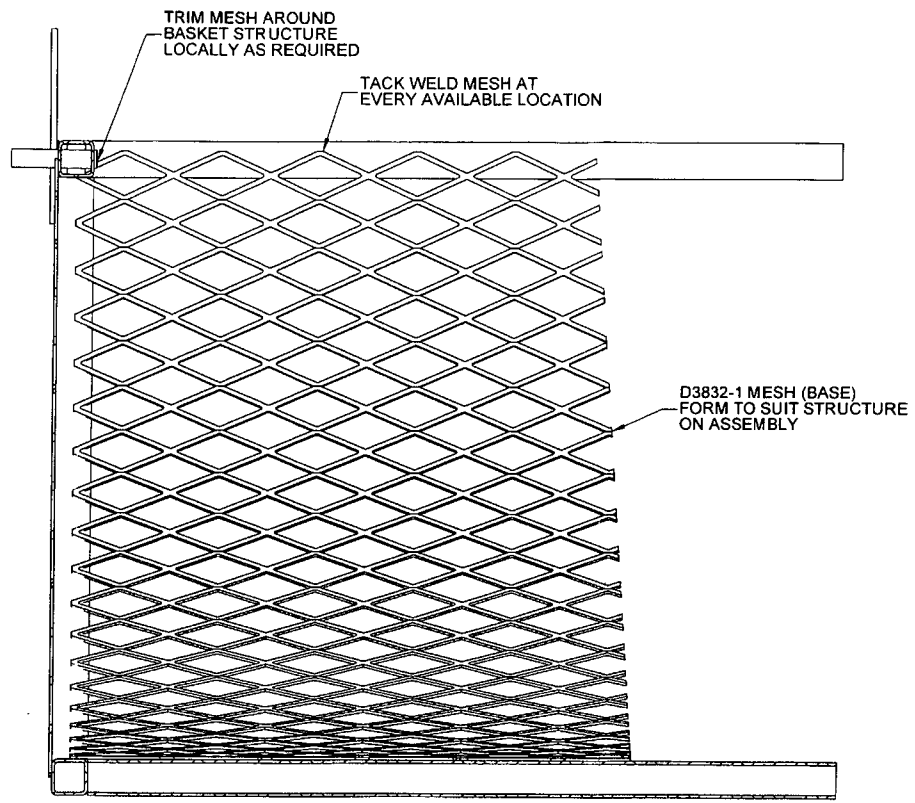
8 7 6 5 4 3 2 1

D
C
B
A

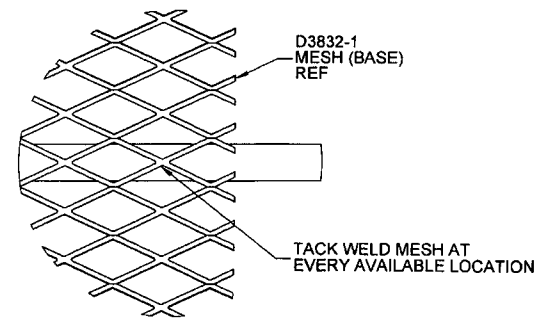
D
C
B
A



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2

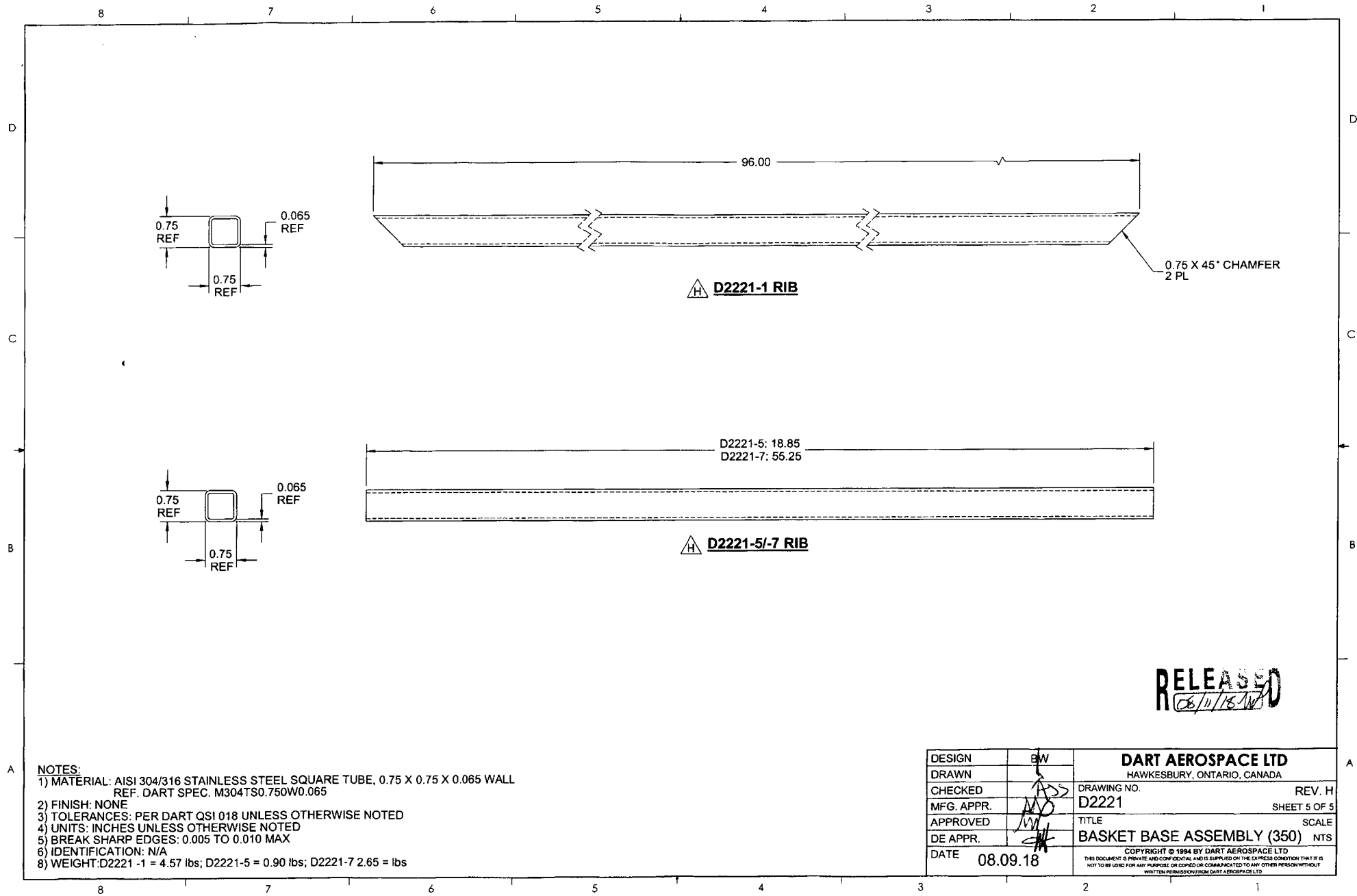


DETAIL E
SCALE 4X C6-2

RELEASED
08/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG. APPR.	MS	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	CH	BASKET BASE ASSEMBLY (350) NTS	
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